

Work Order ID 65580

Page 1

January 20, 2011 9:14:46 AM

Item ID: D3756-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Cushion

Start Date: 1/20/11

Start Qty: 3.00



Cust Item ID:

Required Date: 2/04/11

Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan: C2Date: 11/01/20

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3754

Rev D

D3756

Rev C

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 13330

Manufacture D3754-1 as per Dwg D3754

Upholster as per Dwg D3756

Supplier: Aerotex

Material release note is required

C2 11/01/20 (3)

110

0.00



Receive & Inspect for Damage & Mat'l Certs

Packaging

Memo

0.00

Packaging

Supp/1 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		REPLACE					

Part No: D3756-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>65580</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11.03.16	100	FOAM WAS NOT CORRECT EURONG DENSITY.	CP 11.03.16 OS 042	REPLACE FOAM WITH CORRECT DENSITY B/N <u>13330</u> APPLY 3m 1300L B/N <u>115230</u> TO TWO CONCAVE CORNERS. REF MARKED UP DWG	EP 11/03/22	S 11/03/23	CP 11.03.16 OS 042	S 11/03/23

NOTE: Date & initial all entries

Work Order ID 65580

January 20, 2011 9:14:46 AM



Page 2

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

5.11/03/23



QC

Memo

0.00

Quality Control

x3

130

Identify as per dwg & Stock Location: 252A

0.00



Packaging

Memo

0.00

Packaging

11/3/23

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/23

5.11/03/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

January 20, 2011 9:14:45 AM

Work Order ID: 65580

Parent Item: D3756-041

Parent Item Name: Cushion




Start Date: 1/20/11

Required Date: 2/04/11

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP: A 08.11.17 New issue EC verified by: DD IPP
Rev: B 10.04.13 as per Ec10-539 DD verified by: EC IPP Rev: C
10.05.03 remove velcro per comment (W/O 58261) DD verified: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3756-041P  Cushion		Purchased	No			110	Each	0.0000	1	3			



Cushion (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

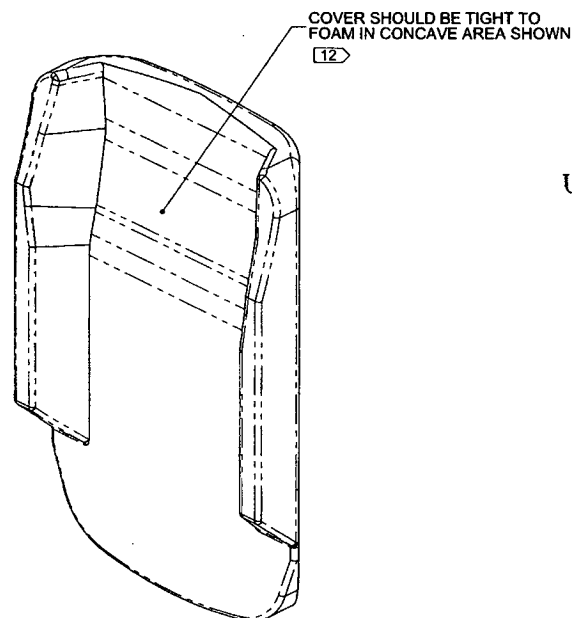
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -1	PART NUMBER	DESCRIPTION
1	X		D3756-041	CUSHION
2	1	X	D3756-1	COVER
3	1		D3754-1	BACK FOAM
4		A/R	HOOK STRIP, 2"	3M SJ3418FR, 2" WIDE BEIGE OR D3800-1-200-600
5		A/R	LOOP STRIP, 1"	3M SJ3418FR, 1" WIDE BEIGE OR D3800-1-100-700
6		A/R	HOOK LOOP, 1"	APLIX 800, A800R0025H958-1, 1" WIDE BEIGE OR D3800-3-100-700
7		A/R	FABRIC	JACKSON GREYMIX
8	A/R	A/R	THREAD	BONDED POLYESTER, 14.2 lb BREAK STRENGTH, GREY COLOR
9	A/R		ADHESIVE	3M 1300 / 1300L RUBBER AND GASKET ADHESIVE OR SILAPRENE DC12906 SPRAY GRADE HPL CONTACT ADHESIVE

△
△
△
△
△



D3756-041 CUSHION

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 65580
C211101/20

RELEASED
2010-03-23
NR

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3756-041" USING LABEL
- 7) WEIGHT: 4.2 lbs
- 8) SEW D3756-1 COVER TO FIT D3754-1 FOAM
- 9) STITCHING: 4-6 STITCHES PER INCH, USE MIN 1/2" BACKSTITCH, NO LOOSE THREADS
- 10) STITCH HOOK AND LOOP STRIP (1") ALONG EDGE OF SEAM TO CLOSE COVER, INSTALL THE LOOP STRIP ON THE TOP OVERLAPPING FLAP, INSTALL THE HOOK STRIP ON FABRIC NEXT TO FOAM
- 11) CUSHION SHAPE / FORM / PATTERN TO CONFORM WITH TEMPLATE DT9420
- 12) TO PULL FABRIC AGAINST FOAM IN CONCAVE AREAS, STITCH FOAM TO FABRIC AS REQ'D OR BOND WITH SILAPRENE DC12906 SPRAY GRADE HPL CONTACT ADHESIVE OR 3M 1300/1300L RUBBER AND GASKET ADHESIVE

C	UPDATE TO VIEWS/NOTES FOR RE-SHAPED D3754-1 BACK FOAM & NEW MFR; FABRIC, HOOK, LOOP, ADHESIVE CHG (D5-1); 29.75 WAS 27.00 (C1-2); REF PAR 09-030.	CP	10.02.02
B	COVER NOW CLOSED WITH SINGLE SEAM (ZN A8-1, B8-2). D3800-1-100-300 WAS D3800-1-100-650 (D8-1). D3800-3-100-300 WAS D3800-3-100-650 (C8-1). ADD ITEM NUMBERS TO PART LIST (D8-1). 17.75 WAS 18.00 (D2-2)	CP	08.10.21
A	NEW ISSUE	CP	08.09.09
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.02.02		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3756** REV. C
SHEET 1 OF 2
TITLE **CUSHION** SCALE NTS

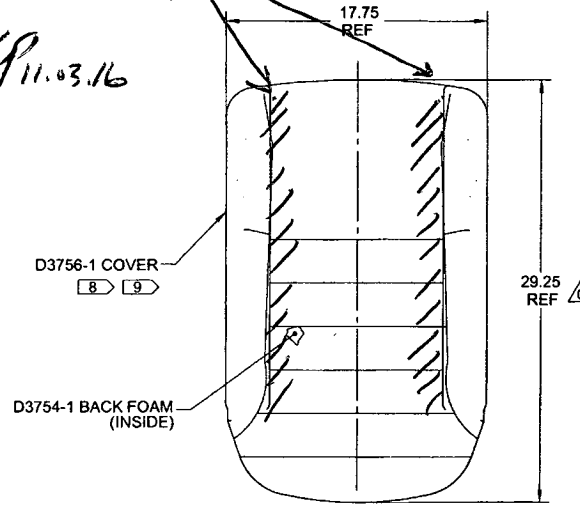
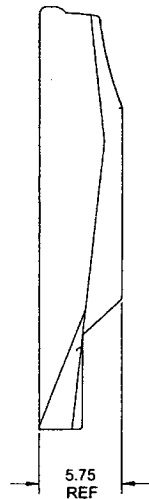
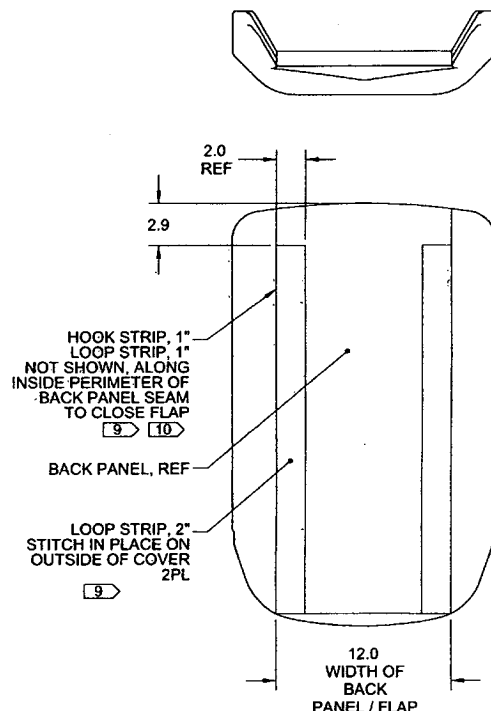
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SHOP COPY 1

RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 65580

3M 1300L
REF ON FORM
TO BOND COVERS

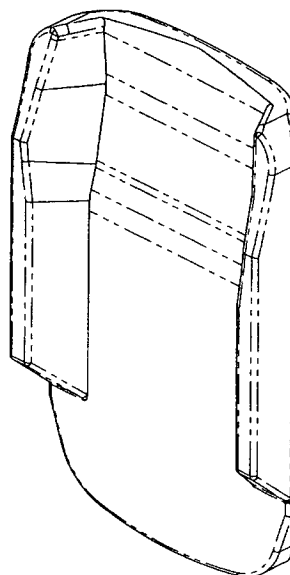
9/11.03.16



D3756-041 CUSHION

RELEASED
2010-03-23

DESIGN		DART AEROSPACE LTD	
DRAWN	GP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. C
MFG. APPR.	CE	D3756	SHEET 2 OF 2
APPROVED	TH	TITLE	SCALE
DE APPR.	TH	CUSHION	NTS
DATE	10.02.02	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D3754-1 BACK FOAM

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 65580

RELEASED
2010-03-23

NOTES:

- 1) MATERIAL: FOAMEX H250-35S1 FOAM
OR
AIRFLEX FIRE-RESISTANT AIRCRAFT CUSHIONING, GRADE 30-40 (COLOR: LIGHT GREEN)
SUPPLIER: CHESTNUT RIDGE FOAM INC., P/N 603150-99
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3754-1" USING PERMANENT INK MARKER
- 7) WEIGHT: 2.2 lbs APPROX
- 8) FOAM SHAPE TO CONFORM WITH TEMPLATE DT9028

D	ADD SHT 2: ALL PRIMARY VIEWS MOVED TO SHT 2; DIM 3.00 WAS 4.00 (B8-2); 29.25 WAS 27.00 (C3-2); 6.50 WAS 4.25 (B3-2); ADD FOAMEX MATL (A8-1), REF PAR 09-030	CP	10.02.02
C	CHG DIMS PER CHESTNUT SAMPLE: 17.75 WAS 18.00 (D6-1)	CP	08.10.08
B	REMOVE 'HUMP' IN LOWER PART OF FWD (CONCAVE) SIDE (C5-1)	CP	08.09.09
A	NEW ISSUE	CP	08.04.25
REV.	DESCRIPTION	BY	DATE
DESIGN	GP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	GP		
CHECKED	GP	DRAWING NO.	REV. D
MFG. APPR.	GP	D3754	SHEET 1 OF 2
APPROVED	GP	TITLE	SCALE
DE APPR.	GP	BACK FOAM	NTS
DATE	10.02.02	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO13330

Purchase Order Date 1/20/11

PO Print Date 2/15/11

Page Number 1 of 1

Order From :

VC-AER003

AEROTEX INTERIORS INC.
#24-2333 18TH AVENUE N. E.
CALGARY, AB T2E 8T6
CA

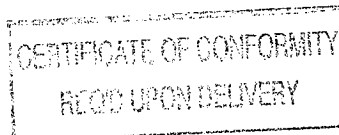
Contact Name
Vendor Phone 403 295 8770
Vendor Fax 403 313 0793
Vendor Account Nbr

Buyer Chantal Lavoie
Requisition Nbr
Tax Resale Nbr 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

Ship To :

DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D3755-041P	Seat Cushion	2/04/11 Yes	3.00 Each	FedEx PI collect	\$425.0000	\$1,275.00
		Special Inst:	AS PER DWG D3755 REV. C B65579				
2	D3756-041P	Cushion	2/04/11 Yes	3.00 Each	FedEx PI collect	\$425.0000	\$1,275.00
		Special Inst:	AS PER DWG D3756 REV. C B65580				
PO Total:							\$2,550.00



Change Nbr: 2

Change Date: 2/15/11

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



#24, 2333 - 18 Ave NE
Calgary, AB T2E 8T6
Phone: (403) 295-8770
Fax: (403) 313 0793

Packing Slip

Date	Packing Slip#
15/02/2011	7875

Ship To	
Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7 Canada	
Customer Phone	Customer Fax
613.632.5200	613.632.1053
Ship Via	Courier Acct No.
FED EX	1517-9324-0

Invoice To
Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7 Canada

Ship Date	P.O. No.
15/02/2011	13330

Aircraft	Description	Part Number	Qty
DART DART	BACK CUSHION SEAT CUSHION GST On Sales	D3756-041 D3755-041	3 3

Thank you for your business.

www.aerotextinteriors.com

GST/HST No. 139110308



- Unit 24, 2333 - 18 Ave NE, Calgary AB T2E 8T6 - Phone: (403) 295 -8770 - Fax: (403) 313 - 0793 -

CERTIFICATION OF CONFORMANCE

Customer Purchase Order:
Our Work Order:

13330
7875

THIS IS TO CERTIFY THAT THE FOLLOWING MATERIALS HAVE BEEN USED IN THE WORK ORDER STATED ABOVE:

PILOT GREY MIX FABRIC

1" VELCRO LOOP - BEIGE - D3800-1-100-700

1" VELCRO HOOK - BEIGE - D3800-3-100-700

2" VELCRO LOOP - BEIGE - D3800-1-200-600

FOAM - H270-40S1

FOAM - H250-35S1

THREAD - BONDED POLYESTER, 14.2 lb BS Grey

ADHESIVE - 3M 3100 RUBBER ADHESIVE

ZIPPER - PACANNA BRASS AUTOLOCK ZIPPER #5

FOAM - FOAMEX H270-40S1

FOAM - FOAMEX H270-35S1

HAS BEEN FABRICATED TO ESTABLISHED SPECIFICATION TO CONFIRM WITH
DWG NO. D3755 REV. C and DWG NO. D3756 REV. C

SOLD TO:

DART AEROSPACE LTD., 1270 ABERDEEN STREET, HAWKESBURY, ON K6A 1K7

AUTHORIZED REPRESENTATIVE

A large, stylized handwritten signature is written over the line for the authorized representative.